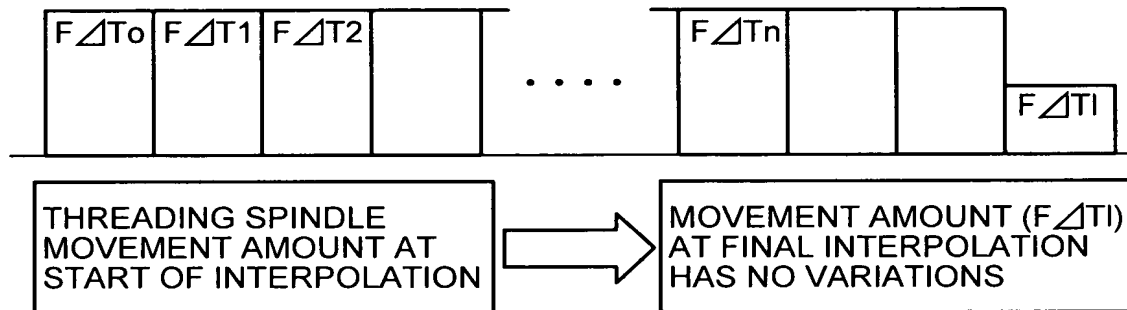
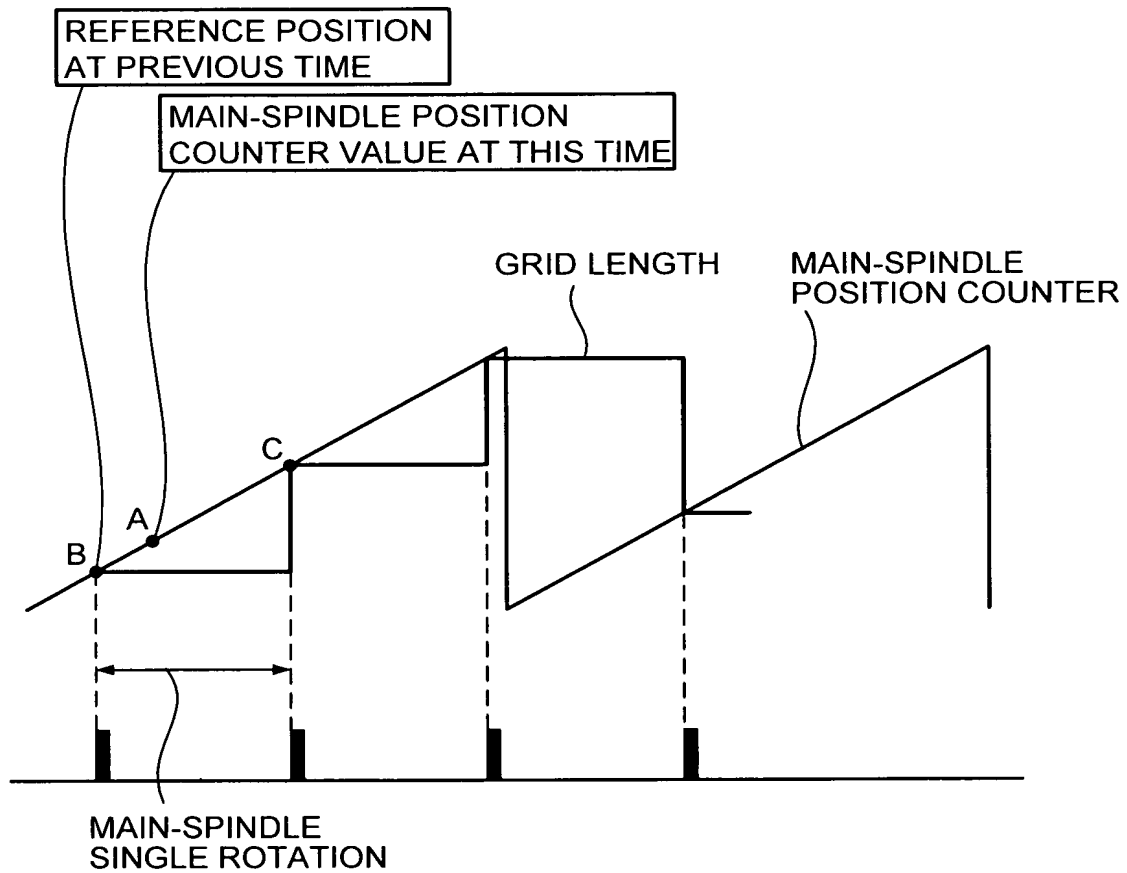


FIG. 3



$F\Delta T_s$:MAIN-SPINDLE MOVEMENT AMOUNT PER CONTROL CYCLE
 $F\Delta T_{sc}$:POST-CORRECTION MAIN-SPINDLE MOVEMENT AMOUNT PER CONTROL CYCLE
 $F\Delta T_z$:THREADING-SPINDLE MOVEMENT AMOUNT PER CONTROL CYCLE
 $F\Delta T_0$:THREADING-SPINDLE MOVEMENT AMOUNT AT FIRST INTERPOLATION
 $F\Delta T_n$:THREADING-SPINDLE MOVEMENT AMOUNT AT SECOND AND SUBSEQUENT INTERPOLATIONS
 $F\Delta T_I$:THREADING-SPINDLE MOVEMENT AMOUNT AT FINAL INTERPOLATION
 ΔT :CONTROL CYCLE

FIG. 4



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FIG. 5

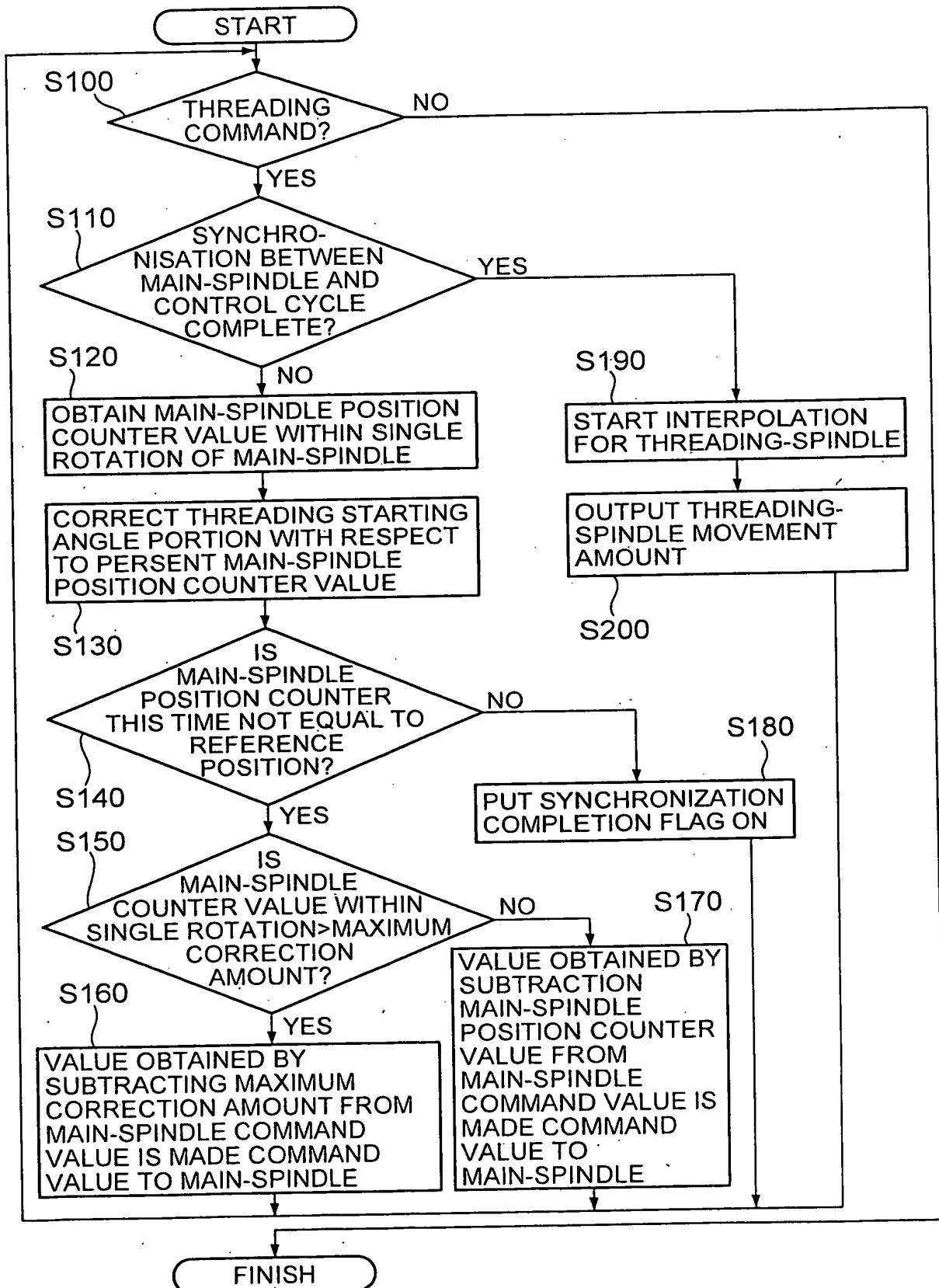


FIG. 6

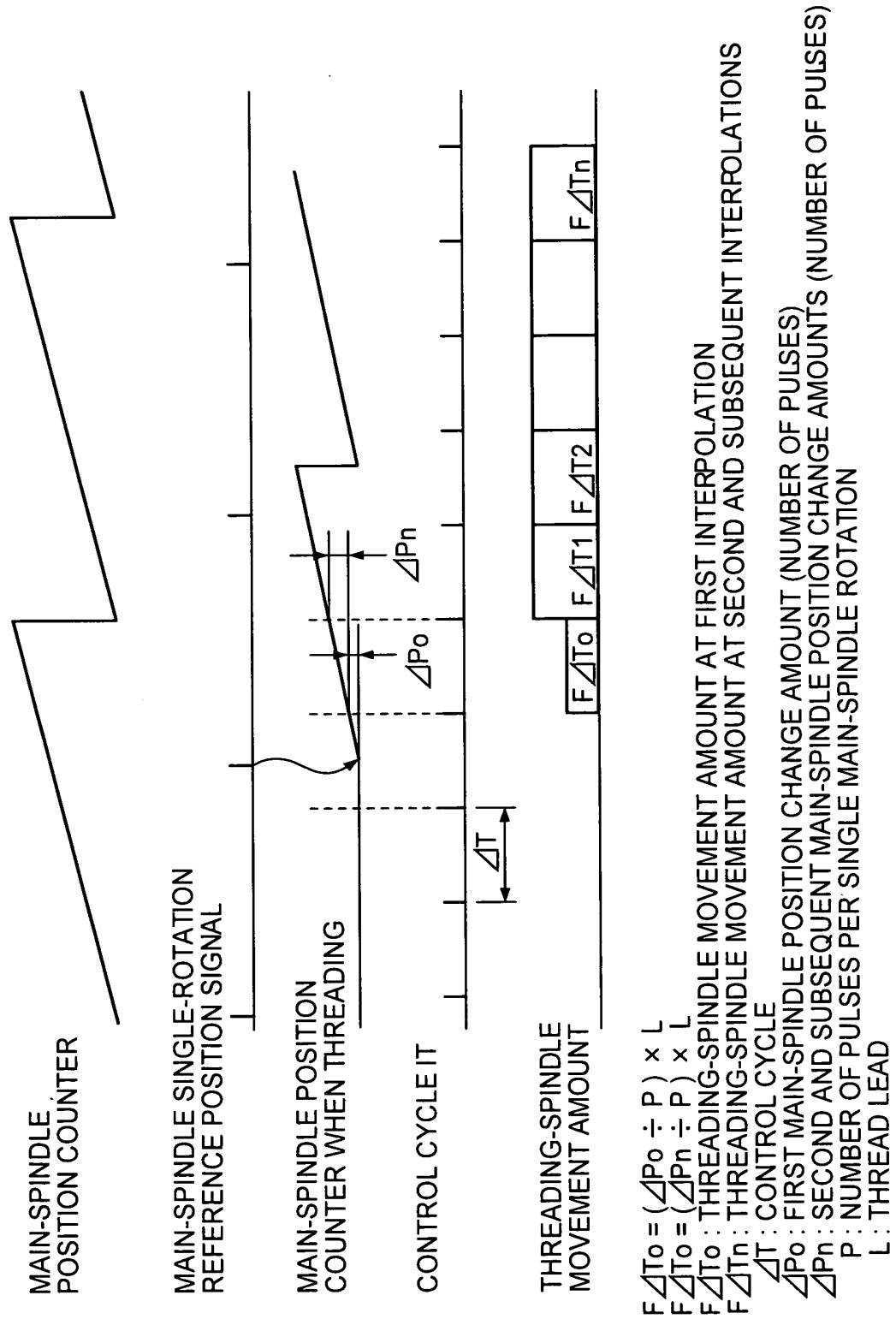
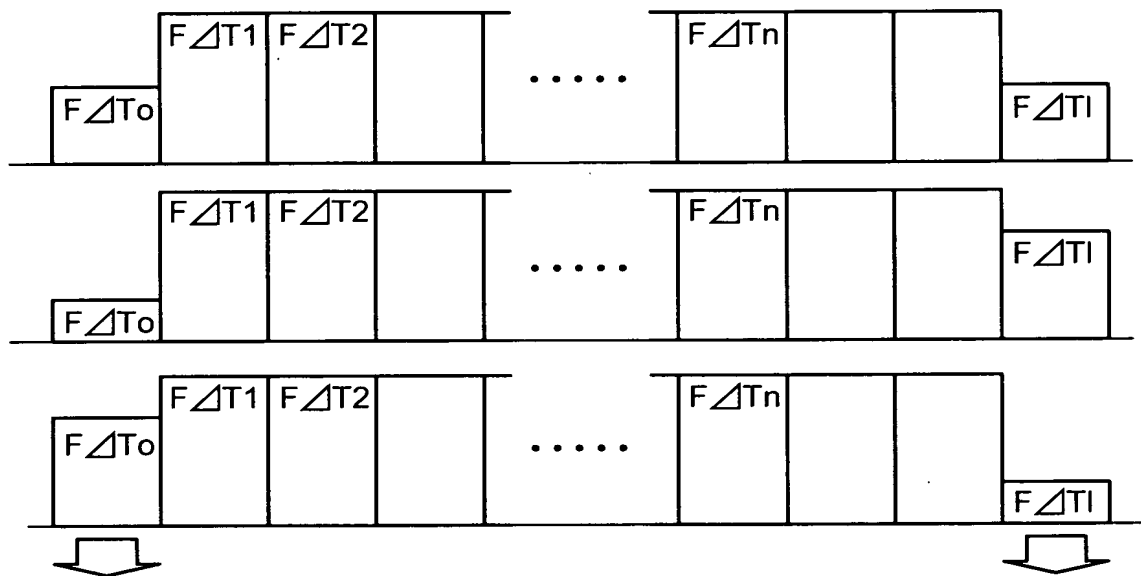


FIG. 7



SINCE MAIN-SPINDLE ROTATION CYCLE AND CONTROL CYCLE ARE ASYNCHRONOUS, VARIATIONS OCCUR IN THREADING-SPINDLE MOVEMENT AMOUNT ($F\Delta T_0$) FOR FIRST INTERPOLATION

DUE TO VARIATIONS IN THREADING-SPINDLE MOVEMENT AMOUNT, DESCRIBED ON THE LEFT, VARIATIONS OCCUR IN THREADING-SPINDLE MOVEMENT AMOUNT ($F\Delta T_I$) FOR FINAL INTERPOLATION

FIG. 8

